

Date: Friday, 20/02/2009 10:56:37 AM
User: Jean-Luc Menard

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ADAPTER
Job Number :	45928		
Estimate Number :	12674		
P.O. Number :		Part Number :	D35733
This Issue :	20/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3573 REV.A
First Issue :	//	Project Number :	N/A
Previous Run :	34247	Drawing Revision :	A
Written By :	<i>[Signature]</i> 09.02.20	Material :	
Checked & Approved By :		Due Date :	27/02/2009
Comment :	Est Rev:A New Issue 07-01-29 JLM		

Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X02500 6061-T6 Bar .500 x 2.50



Comment: Qty.: 0.3066 f(s)/Unit Total : 2.4528 f(s)
6061-T6 Bar .50" x 2.5"
Batch: M104366

28 09/02/22 (8) (16)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blank 3.500" long

28 09/02/22 (7) (16)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA673 and Dwg D3573

J-F 09/02/23 (16)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F 09/02/23 (16)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J-L 09/02/23

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FX 09/02/23 (16)

Date: Friday, 20/02/2009 10:56:37 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 45928

Part Number: D35733

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M109649



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

8:40AM

OVEN TEMPERATURE:

320°C

FINISH TIME:

9:10AM

JFL

09-02-24

X 16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



16

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-02-24

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

JFL

09/02/24

X 6

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-02-24

DART AEROSPACE LTD		Work Order:	45928
Description: Adapter		Part Number:	D3573-3
Inspection Dwg: D3573 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

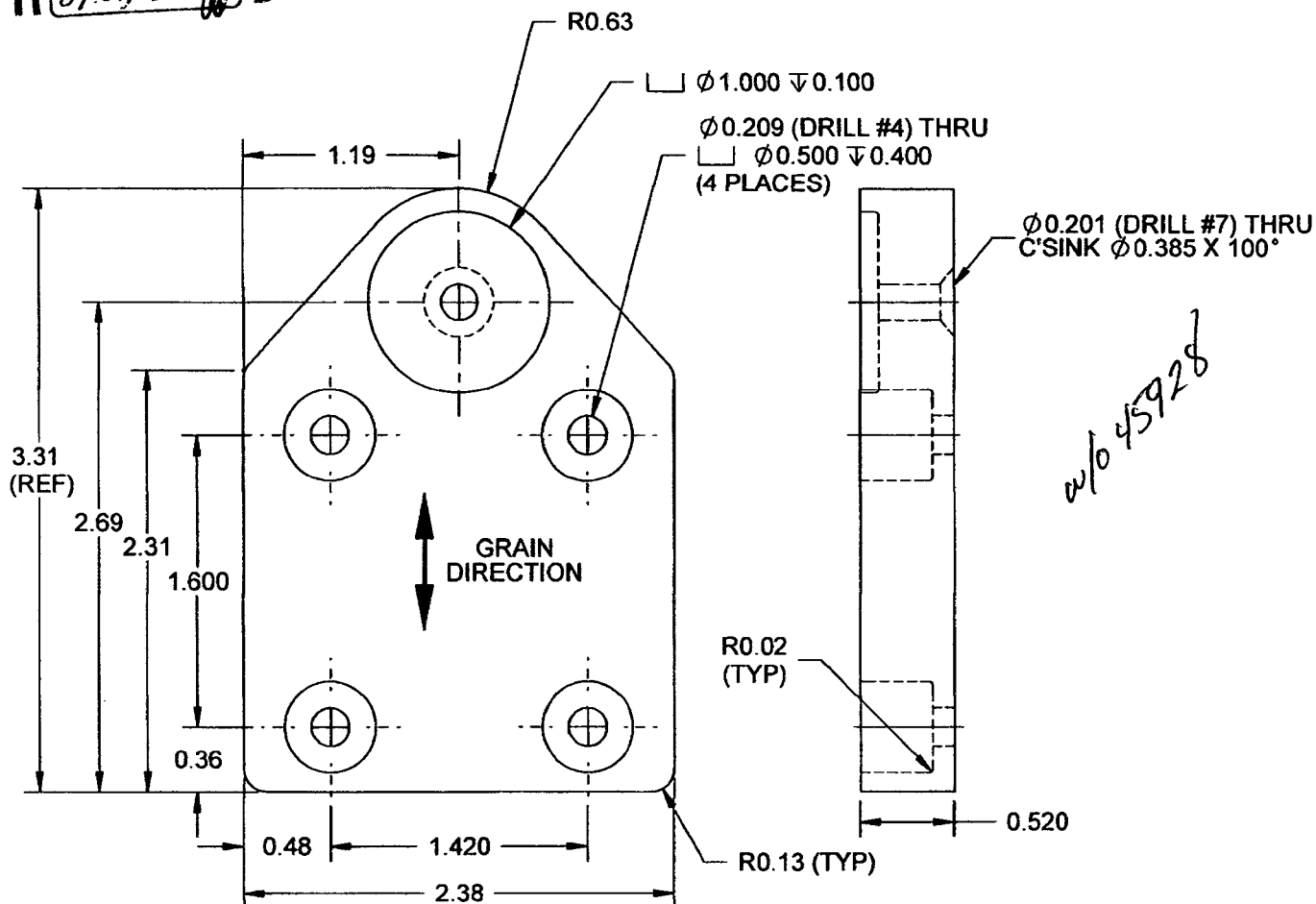
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3.311"	✓			
2.69	+/-0.030	2.688"	✓			
2.31	+/-0.030	2.310"	✓			
1.600	+/-0.005	1.600"	✓			
0.36	+/-0.030	0.356"	✓			
1.19	+/-0.030	1.188"	✓			
2.38	+/-0.030	2.376"	✓			
1.420	+/-0.010	1.420"	✓			
0.48	+/-0.030	0.477"	✓			
R0.63	+/-0.030	R. 630"	✓			
R0.13	+/-0.030	R. 130"	✓			
R0.02	+/-0.030	R. 020"	✓			
Ø0.209	+0.005/-0.001	Ø. 214"	✓			
Ø0.266	+0.006/-0.001	Ø. 268"	✓			
0.390	+0.010/-0.000	0.394"	✓			
Ø0.675 x 0.190	+/-0.010	Ø. 680 x .189"	✓			
Ø0.500 x 0.310	+/-0.010	Ø. 502 x .310"	✓			

Measured by:	J.F.	Audited by:	J.L.	Prototype Approval:	N/A
Date:	04/02/22	Date:	09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.04	New Issue	KJ/JLM	

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07-03-22



D3573-1 ADAPTER

NOTES:

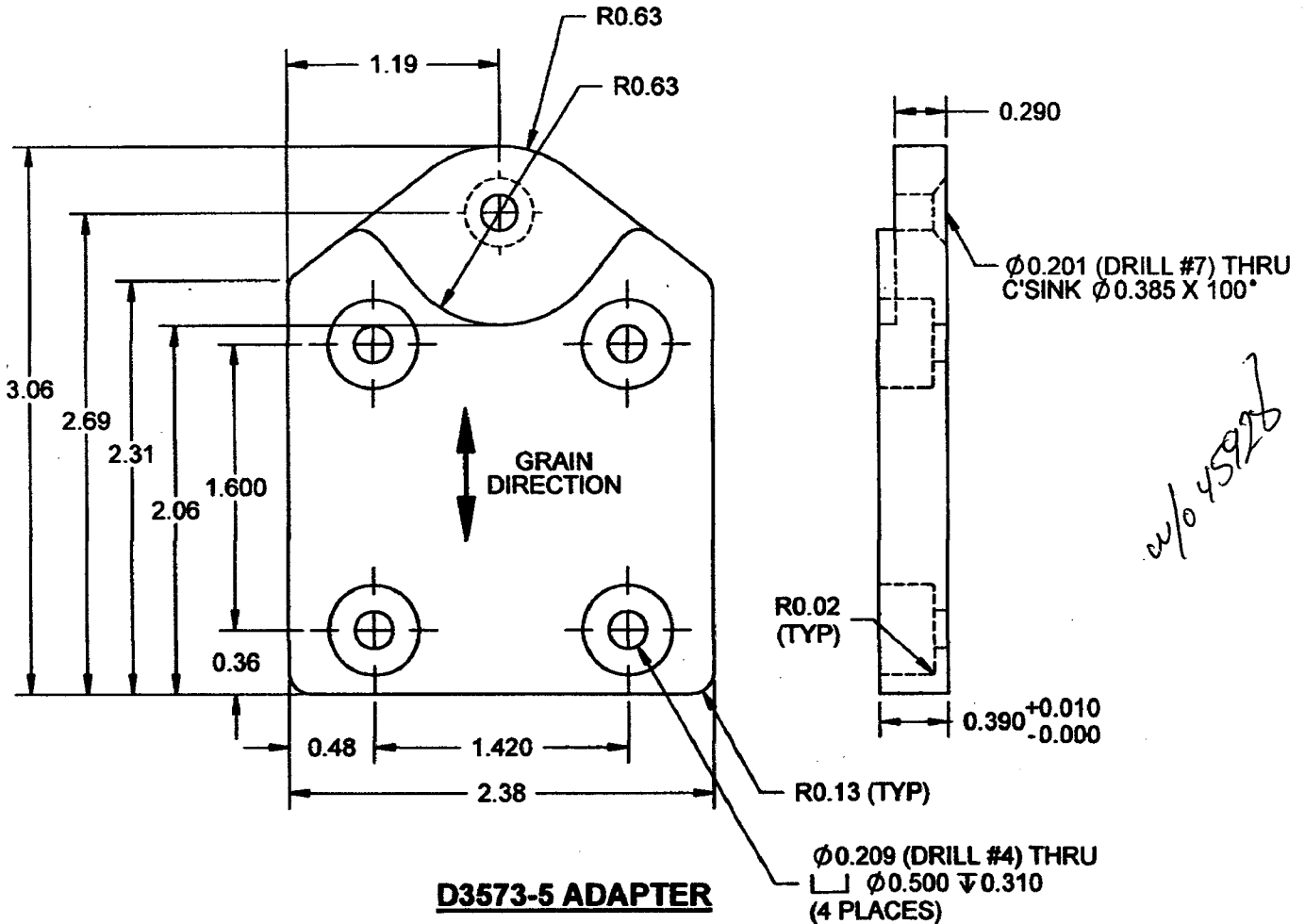
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 3 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

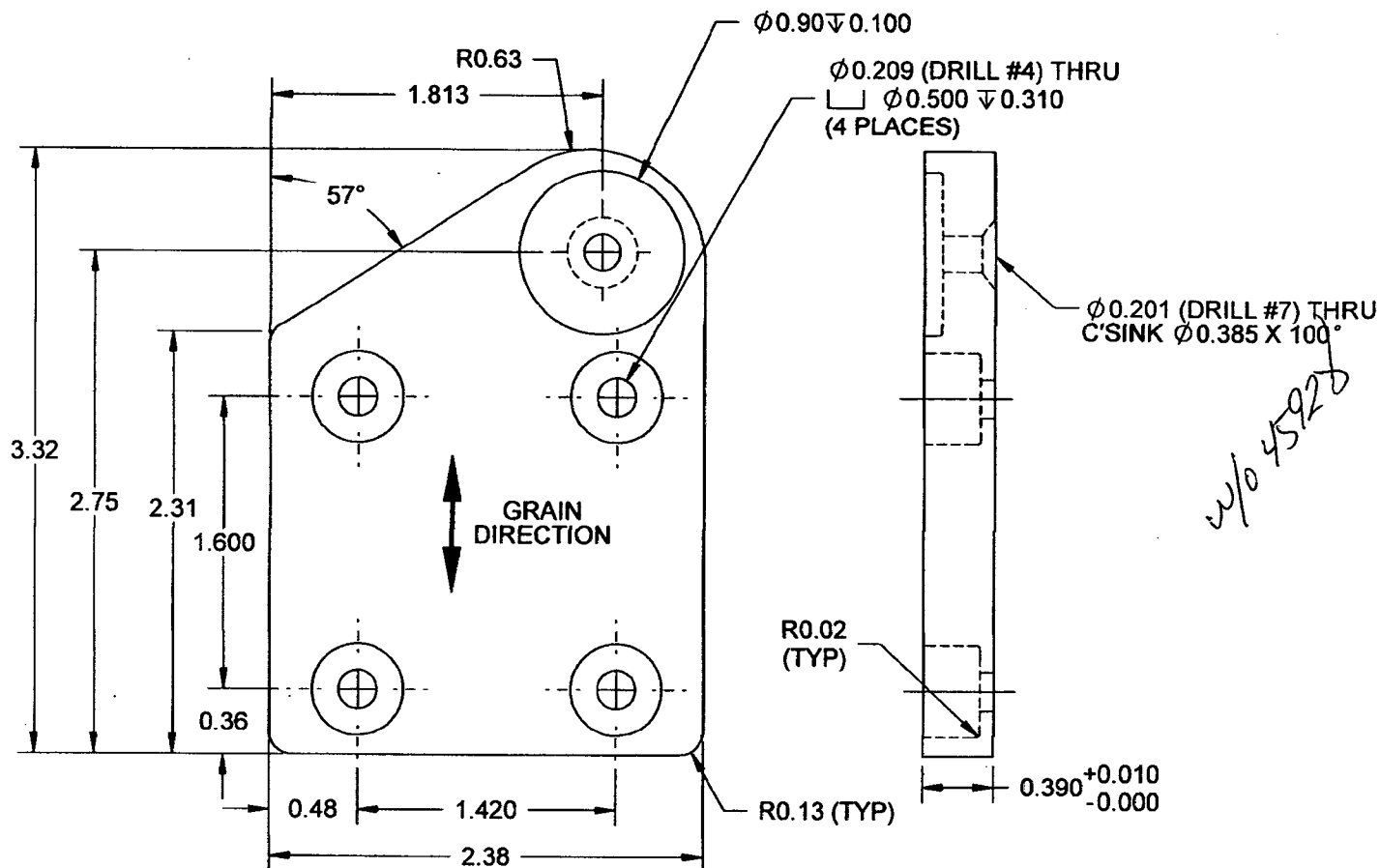
COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02 *[Signature]*



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.